

Work Order ID 61767

Thursday, September 02, 2010 11:27:59 AM



Page 1

Item ID: D350-748-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: H Date: 09-02 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-241	Rev E								

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPPD350-748-201 CHG001

Subtotal

for CL 11/02/03

DP

10-12-2

110



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

0.00

Memo

0.00

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT _____

DP

10-12-7. Pto

120



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

8/10/07

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: _____ Fault Category: x-tubes NCR: Yes No DQA: 1 Date: 11/02/07
 Resolution: Accepted Disposition: use as is QA: N/C Closed: X Date: 11/02/07

NCR: <u>61767</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.11.07	110	Tube is bent high (0.210" above nominal) RC process	CP 10.11.07 CPS1042	Acceptable	NA	S 10/12/06	CP 10.11.07 CPS1042	S 10/12/06

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
	HandFXtube								
Hand Finishing Crosstubes	Memo ***Stress relief*** Heat treat crosstube as per QSI010 4.3	0.00							
127	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

Start time 2:00
End time 6:00
SAP 10-12-08

8/12/08

Re measure use second
PAZ sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Required Date: 9/20/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00				①			
Crosstubes	Memo	0.00							
Crosstubes	1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-241								
	4-Remove all marks from tube within limits of D350-748-241								
	5- Apply a light coat of LPS3 on the interior of tube Batch: 109956								
140	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

140.5

DEFLECT XTube

10/12/21

issue 710 acumen for WPT

PID: 13181

10/12/21 ①

rec'd + inspect attached report WPT to W10!

10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Outsource process-Cadplate per QSI017 4.1.9.1 0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 13189
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

CZ 10/12/22 ①

160 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

10/1/18 ①

170 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Sublet 24 11/01/24

SPM 2 81.8125

twist = 0.064" issue P/O to ensure LPI as per ASTM 1417 level 2 as LPI as per QSI 038

P/O 13367 CZ 11/01/26 ①

rec'd + inspect + attached c/c to W/O

11/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Start Date: 9/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abraison strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/2010

Memo

0.00

(K)

220



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/2/38

230



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/2010

Memo

0.00

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Cust Item ID:

Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPPD350-748-201								
	Location: <u>102</u>								
	PPP Rev: <u>A</u>								
250	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

11/2/358

11/02/04

MF

11-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 02, 2010 11:28:03 AM

Page 1

Work Order ID: 61767

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-241TRN		Manufactured	No			110	Each	3.0000	1	1			
Crosstube Turning Detail													

Location	Loc Qty	Loc Code
LG	3	
59549	1	
59551	1	
59587	1	

ALS4-1032-225	Purchased	No			200	Each	5,336.000	1	1				
Insert													

Location	Loc Qty	Loc Code
PK011	5336	
110768	5336	

AN960JD10	NAS1149D0363J	Purchased	No		200	Each	6.0000	1	1				
Washer													

Location	Loc Qty	Loc Code
ST	6	
107715	6	

B#116025

DP 10-12-7

11-02-02

11-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

Work Order ID: 61767

Parent Item: D350-748-201


Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00


Required Qty: 1.00

D2856-400 Manufactured No 200 f 313.4060 1.181 1.243158

 Abraison Strip


13# 63735

Location	Loc Qty	Loc Code
ST403	313.4060421	
56626	97.4060421	
59920	216	

1- cut as per dwg D2856

D3502-1 Manufactured No 200 Each 54.0000 2 2

 Support

Location	Loc Qty	Loc Code
ST063	12	
61206	12	
ST066	42	
50287	38	
52903	4	

MS21920-20 Purchased No 200 Each 77.0000 2 2

 Clamp (per MIL-DTL-8783C)

13# 115736

Location	Loc Qty	Loc Code
LG	77	
112624	6	
114687	21	
114779	24	
115057	26	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, September 02, 2010 11:28:03 AM

Work Order ID: 61767

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

200

Each

126.0000

1

1



Screw



ml 11.02.02

Location

Loc Qty

Loc Code

ST291

126

112794

26

112940

100

AN4-41A

Purchased

No

220

Each

274.0000

8

8



Bolt



11/2/3sf

Location

Loc Qty

Loc Code

ST337

40

ST360

234

111424

4

113359

30

114941

100

115108

100

AN4-6A

Purchased

No

220

Each

1,418.000

16

16



Bolt



11/2/3sf

Location

Loc Qty

Loc Code

ST356

1418

112933

96

113149

19

114523

2

114615

1

114941

500

115108

300

115457

500

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61767

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-32A

Purchased

No

220

Each

196.0000

Bolt

Location

Loc Qty

Loc Code

ST340

196

113121

4

114056

42

114405

50

115016

50

115108

50

AN960JD416

NAS1149D0463J

Purchased

No

220

Each

0.0000

Washer

AN960JD516

NAS1149D0563J

Purchased

No

220

Each

34.0000

Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D3500-1

Manufactured

No

220

Each

30.0000

Saddle

Location

Loc Qty

Loc Code

ST424

30

55605

2

59422

16

60489

12

Thursday, September 02, 2010 11:28:03 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

D350T-1

Manufactured No

220

Each

394.0000

16

16

11X

1361837 11/2/38



Bushing

Location

Loc Qty

Loc Code

ST066

394

45402

15

45918

112

48268

67

53779

100

61196

100

MS21042L4

Purchased No

220

Each

2,363.000

24

24

1116548



Nut

Location

Loc Qty

Loc Code

ST300

2363

113422

68

114523

28

114718

16

114784

331

115108

1920

MS21042L5

Purchased No

220

Each

633.0000

4

14

1115594 11/2/38



Nut

Location

Loc Qty

Loc Code

ST139

133

114813

133

ST300

500

115156

500

Thursday, September 02, 2010 11:28:04 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

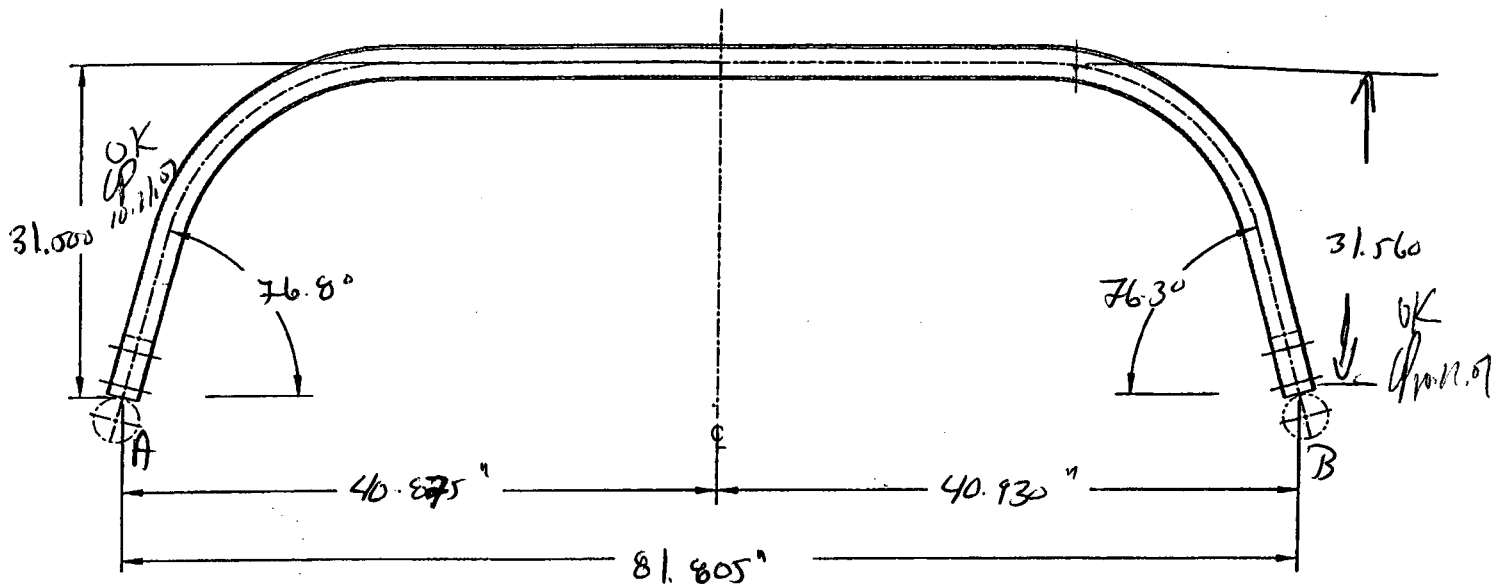
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41717
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
twist = 0.136° OK 10.11.07

QC15 Inspection	8
Date	10/10/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

1
 40.930
 40.875
 81.805

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

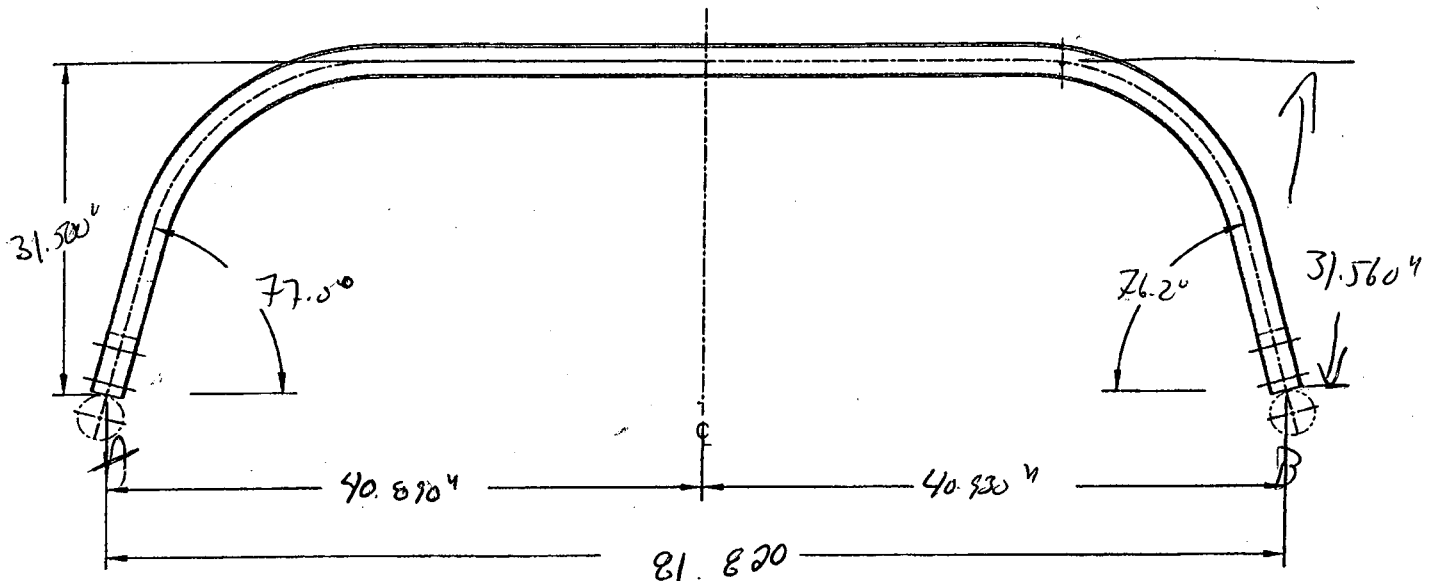
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E			Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



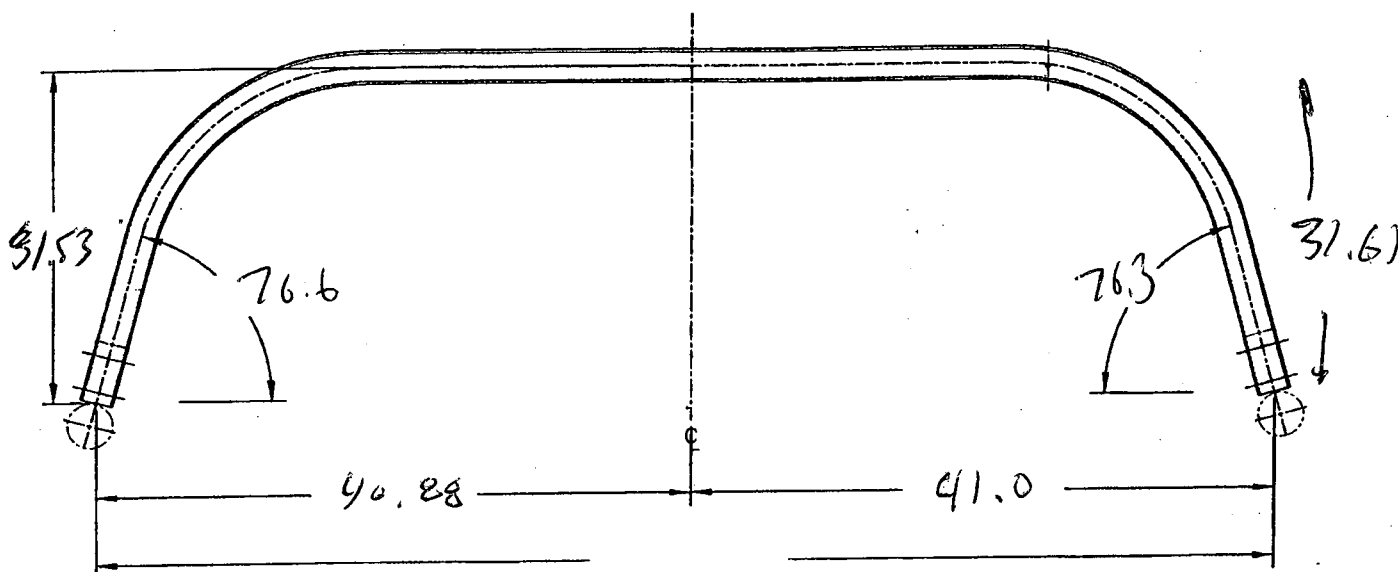
After Stress Relief.	
Twist	0.143 0.140"

QC15 Inspection	8
Date	10/12/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E			Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
AFTER DEFLECTION TEST

QC15 Inspection	CP
Date	10.11.22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 01767

BF10-9-02

RELEASED
2009-10-29

E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>RF</i>	D350-748-241	SHEET 1 OF 4
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

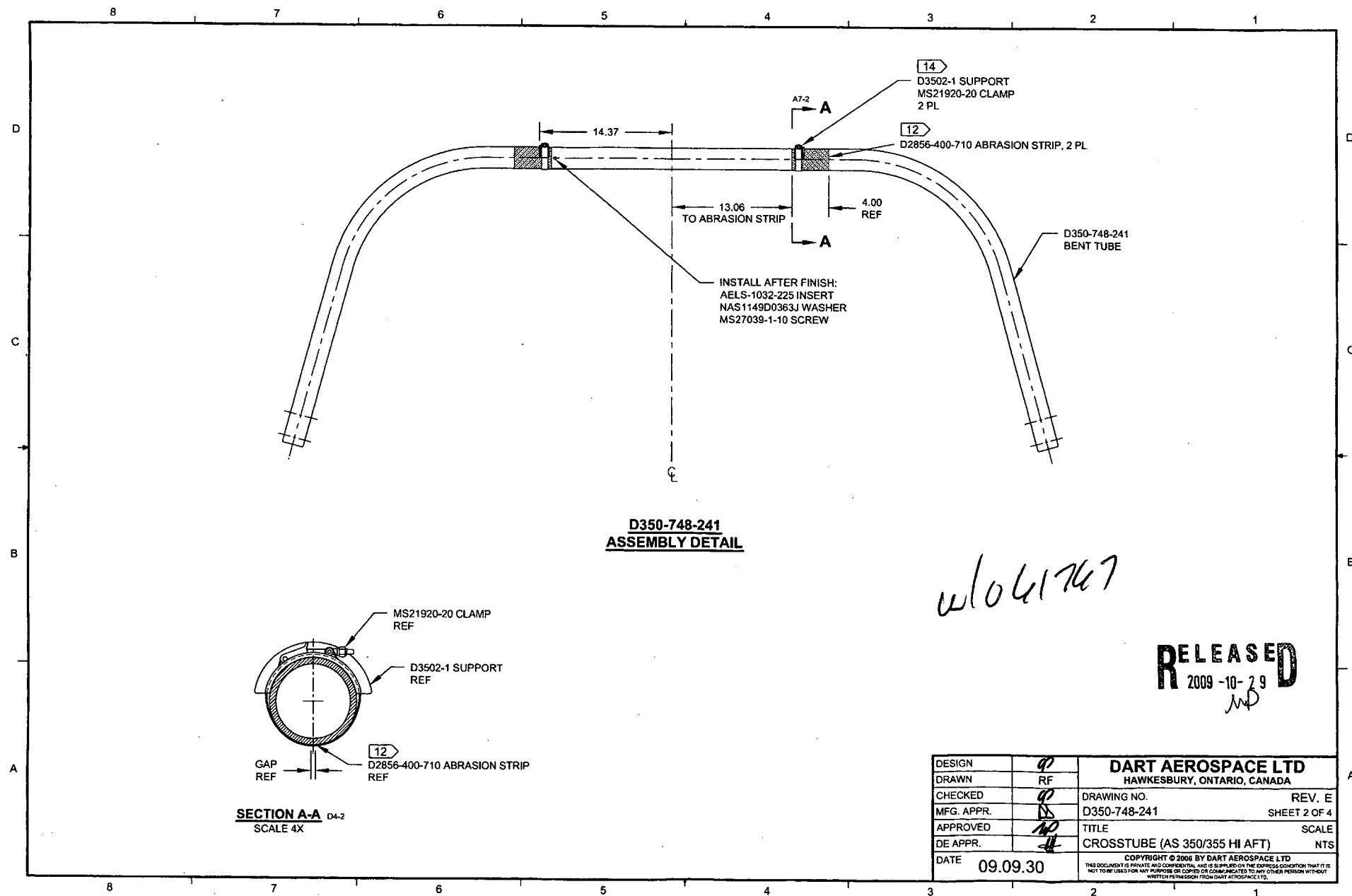
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



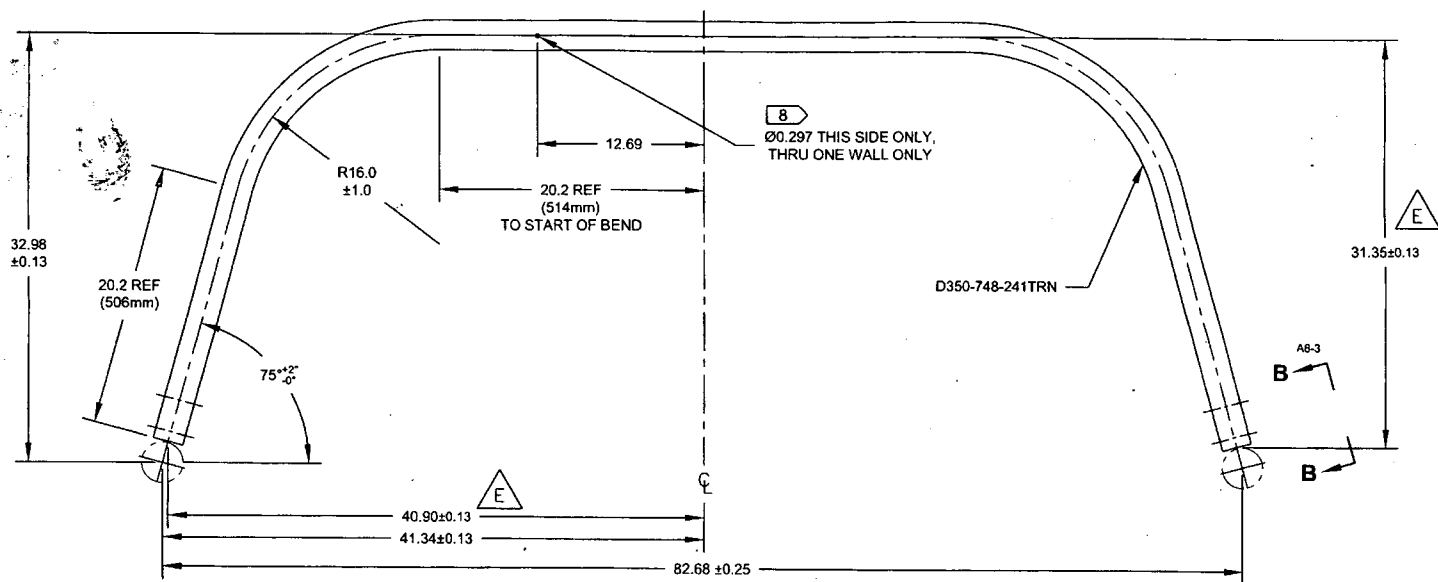
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

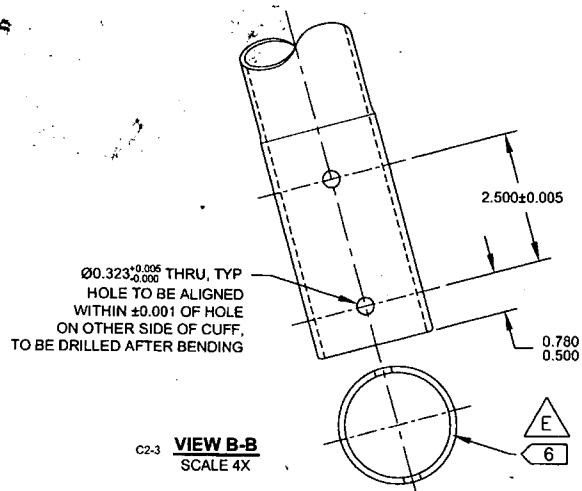
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-241
BENDING AND DRILLING DETAIL 10



u/c 61767

RELEASED
 2009-10-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-241	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

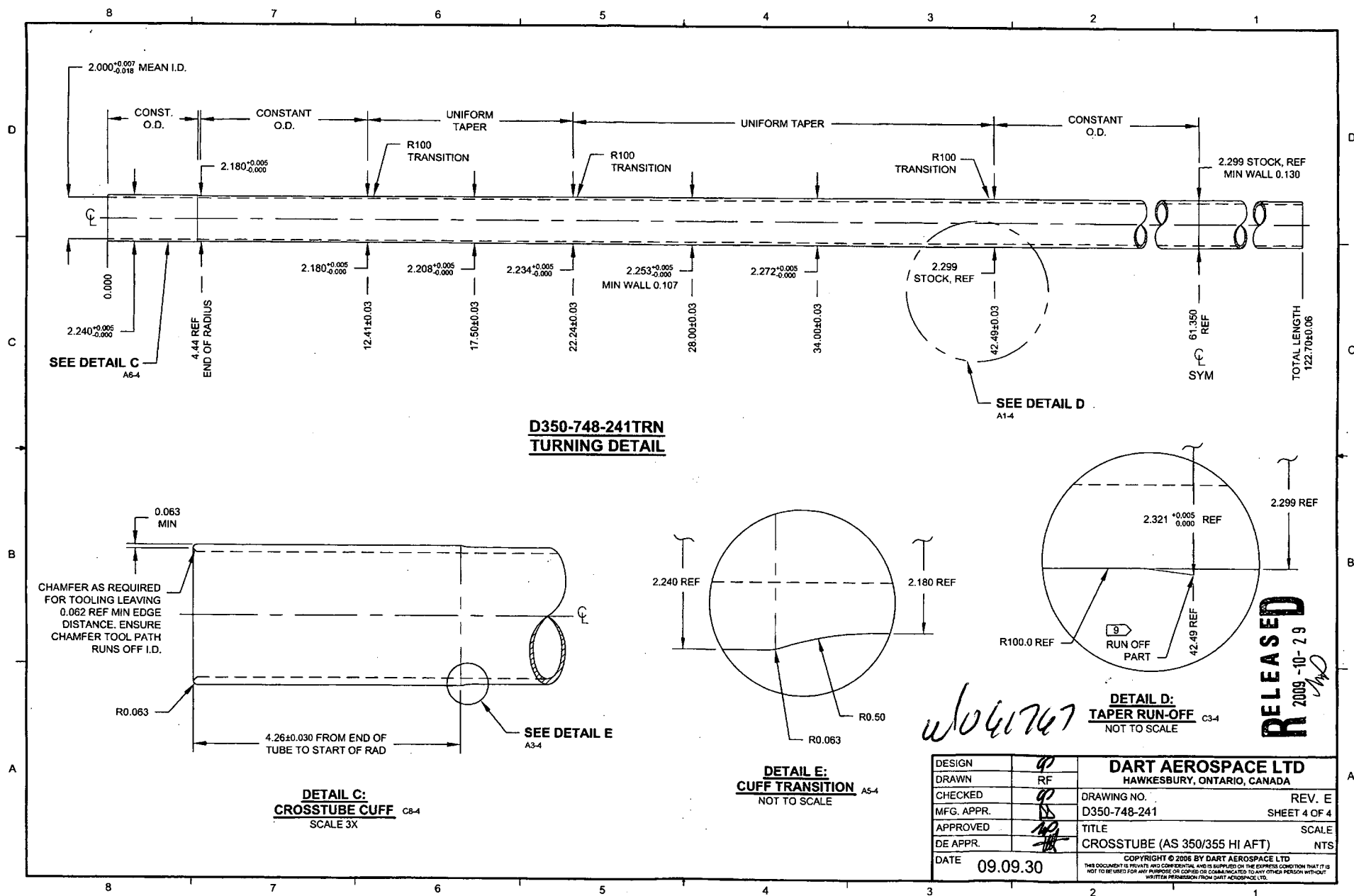
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15199

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE DEC. 21-2010 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-10-0971
ADDRESS 1270 ABERDEEN ST. PO/WO NO. 13181
HAWKESBURY ONT WORK LOCATION HAWKESBURY PLANT
ACCEPTANCE STD. ASTM 1417 REV./DATE 2005
PROJECT SIX CROSS TUBES INSPECT + REINSPECT
ITEM(S) EXAMINED AFTER DEFLECTION PROCESS.

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE 2008 TECHNIQUE NO. LT-002 REV./DATE 2008
PART NO. - MATERIAL STEEL THICKNESS VARIOUS
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE 06-19-2011
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
PHICK
1 - CROSS TUBE-W.O. 61768 ✓
1 - CROSS TUBE-W.O. 61767 ✓
1 - CROSS TUBE-W.O. 61770 ✓
1 - CROSS TUBE-W.O. 61769 ✓
1 - CROSS TUBE-W.O. 63592 ✓
1 - CROSS TUBE-W.O. 63591 ✓
1 - CROSS TUBE-W.O. 61768 ✓
1 - CROSS TUBE-W.O. 61767 ✓
1 - CROSS TUBE-W.O. 61770 ✓
1 - CROSS TUBE-W.O. 61769 ✓
1 - CROSS TUBE-W.O. 63592 ✓
1 - CROSS TUBE-W.O. 63591 ✓
Cross Tubes REINSPECTED
AFTER DEFLECTION
RESULTS AS FOLLOWS.
10.12.21

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE R. Titley DTR # E63236
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL # SNT LEVEL # CGSB LEVEL # SNT LEVEL #
CGSB REG. NO 6606 CGSB REG. NO #

W/O: .		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.12.21	140.5	- DEFLECT TUBE TO <u>3000</u> lbf FOR 1 MINUTE. - RE-MEASURE HEIGHT & WIDTH.	CP	10.12.21		CP 10.12.21 DSI/CP	S 10.12/22	
10.12.21	140.6	NDT Tube following deflection testing.				CP 10.12.21 DSI/CP	S 10.12/22	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jan-14-2011

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 101009

INVOICE #: 52908

**CONTRACT OR
PURCHASE ORDER #**

13189

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201

S/N # **B61767**

**STRESS RELIEF BAKE @375 DEG. BAKE HEAT CHART #11-5. MPI
INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW AMS-QQ-P-
416C, TYPE 2 YELLOW, CLASS 1. BAKE HEAT CHART #11-24.**

S u/a/24

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:





LIQUID PENETRANT TEST REPORT

P- 05496

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

PO/WO NO.

WORK LOCATION

ACCEPTANCE STD.

PAGE

OF

TIME

AM

PM

DART AEROSPACE
LINDA LARCE / CHASTALE / IAN
1270, ABERDEN ST.
HAWKESBURY, ON

JAN/26/2011
188-11-

AS ADDRESS

ASTM1417/AST-038 REV./DATE 2005

WET FLUO PENETRANT INSPECTION ON 14" CROSS TUBES; 4 "collective BEZEL CRACK"

SEE BELOW

JOB DESCRIPTION

PROCEDURE NO. LT-000 REV./DATE 2008

TECHNIQUE NO. LT-000 REV./DATE 2008

PART NO.

MATERIAL ALODINE ALUMINUM THICKNESS N/A

SCOPE

PERFORMED A WET FLUORESCENT LIQUID PENETRANT INSPECTION ON
100% OF THE EXTERNAL SURFACE

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	<u>MAGDA FLUX</u>		BLACK LIGHT S/N <u>13798</u>	OUTPUT > 1000 μ W/cm ²	<input checked="" type="checkbox"/> AMBIENT < 2 fc
PENETRANT	<u>26-67</u>	MINIMUM DWELL TIME 10 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT	OUTPUT > 100 fc @ SURFACE	
PENETRANT REMOVER	<u>H₂O</u>	MINIMUM DRY TIME > 10 MIN.	OTHER		
DEVELOPER	<u>SKD-52</u>	MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N		CAL DUE DATE <u>6/2/2011</u>
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F	<input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F	<input type="checkbox"/> > 52°C/ 125°F	

RESULTS-

☐ METRIC ☒ IMPERIAL

COMMENTS	ACCEPT	REJECT
1 4X "collective BEZEL CRACK"	<input checked="" type="checkbox"/>	
2 CROSS-TUBE W.O. ID 63591	<input checked="" type="checkbox"/>	
3 CROSS-TUBE W.O. ID 63592	<input checked="" type="checkbox"/>	
4 CROSS-TUBE W.O. ID 63746	<input checked="" type="checkbox"/>	
5 CROSS-TUBE W.O. ID 63747	<input checked="" type="checkbox"/>	
6 CROSS-TUBE W.O. ID 63748	<input checked="" type="checkbox"/>	
7 CROSS-TUBE W.O. ID 63749	<input checked="" type="checkbox"/>	

SEE Page 2 of 2

NOID 64913 -> ITEM ID: D350-748-101 (H.F.)
ITEM ID: D350-748-101 (H.F.)
ITEM ID: D350-748-101 (H.F.)
ITEM ID: D350-748-201 (H.A.)
ITEM ID: D350-748-201 (H.A.)
ITEM ID: D350-748-201 (H.A.)
ITEM ID: D350-748-201 (H.A.)

4/1/2011

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE

TECHNICIAN (SIGNATURE):

NAME (PRINT):

CGSB LEVEL

CGSB REG. NO.

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005

RAPPORT D'INSPECTION NON DESTRUCTIVE

(SUITE)

REPORT# P-05496

PAGE 2 DE 2

CLIENT DART AEROSPACE
ATTENTION LINDA LACELLE / CHANTAGE / IAN

DATE JAN/26/2011
ACUREN W/O : 188-11-02103

HEURE ☒ AM ☐ PM

RÉSULTATS (☐ MÉTRIQUE ☒ IMPÉRIALE)

ITEM	Comments	ACCEPT	REJECT	ITEM ID
8	CROSS TUBE W.O. ID 61763	✓		ITEM ID: D350-748-101(H.F.)
9	CROSS TUBE W.O. ID 61764	✓		D350-748-101(H.F.)
10	CROSS TUBE W.O. ID 61765	✓		D350-748-101(H.F.)
11	CROSS TUBE W.O. ID 61766	✓		D350-748-101(H.F.)
12	CROSS TUBE W.O. ID 61767	✓		D350-748-201(H.A.)
13	CROSS TUBE W.O. ID 61768	✓		D350-748-201(H.A.)
14	CROSS TUBE W.O. ID 61769	✓		D350-748-201(H.A.)
15	CROSS TUBE W.O. ID 61770	✓		D350-748-201(H.A.)

— NO REJECTABLE INDICATION WAS DETECTED, AS PER APPLICABLE STANDARD

Étendue des services

L'entente selon laquelle le Groupe Acuren Inc. Exécute les services ne concerne que les énoncés par écrit. En aucune circonstance ces services ne s'étendent au-delà de l'exécution des services demandés. Il est entendu que toutes les descriptions, les observations et les expressions d'opinions faites par Acuren reflètent les opinions ou les observations de l'entreprise fondées sur l'information et les hypothèses fournies par le propriétaire/opérateur, et elles ne constituent pas des déclarations ou des garanties ou ne peuvent être interprétées comme constituant. Le groupe Acuren Inc. N'assume aucune des responsabilités du propriétaire/opérateur, et le propriétaire/opérateur conserve la responsabilité entière des décisions prises en matière d'ingénierie, de fabrication, de réparation et d'usage à partir de l'information ou des données fournies par Acuren en rapport avec les services décrits dans les présentes ne peuvent excéder le coût des services rendus.

Norme de Diligence

Dans l'exécution des services, le Groupe Acuren Inc. Applique le degré de diligence, le soin et la compétence normalement exercés dans des circonstances semblables par d'autres fournisseurs de ce type de services opérant dans la même localité ou dans une localité similaire. Aucune autre garantie, implicite ou explicite, n'est faite ou voulue par le Groupe Acuren Inc.

SIGNATURES

REPRÉSENTANT CLIENT	<u>Jan T. Hey</u>	FTJ#: <u>EG3121</u>
TECHNICIEN (SIGNATURE):	<u>[Signature]</u>	RAPPORT
NOM (MOULIÉ):	<u>JAN T. HEY</u>	RÉVISÉ PAR:
		NOM
		INITIALES
ONGC NIVEAU <u>2</u> 1 ^{er} TECHNICIEN	ONGC NIVEAU <u>2</u> 2 nd TECHNICIEN	
ONGC N° REGISTRATION <u>3249</u>	ONGC N° REGISTRATION <u>—</u>	

REFERENCE ONLY**5.0 PARTS LIST**

Qty -101	Qty -201	Part Number	Description
X	X	D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

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Revision: **B**

Date: 07.06.15